



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3640-1

Job Sheet 180847



Part No: D3640-1

Job Qty: 10 ea

Part Name: Belt Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 8/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-01-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/10/18	8/10/18	0.00	0.00	Start Up Machining-2		<i>[Signature]</i> DAS 54 9-89
100	Bandsaw	10 pcs	8/10/18	8/10/18	0.00	0.22	Bandsaw1		<i>[Signature]</i> DAS 54 9-89
110	CNC Vertical Machining	10 pcs	8/10/18	8/10/18	0.33	3.11	HAAS1-4		<i>[Signature]</i> DAS 54 9-89
130	QC	10 pcs	8/10/18	8/10/18	0.00	0.00	QC8 Machining-2		<i>[Signature]</i> DAS 54 9-89
140	Packaging	10 pcs	8/10/18	8/10/18	0.00	0.00	Packaging3-1	570 46 88	<i>[Signature]</i> DAS 54 9-89
150	QC21-SA	10 Ea	8/10/18	8/10/18	0.00	0.00	QC21		<i>[Signature]</i> DAS 54 9-89

Part Op 100 - Cut blank 4.700 " long

Descriptions: 110 - 1- Mill as per Folio FA670 & Dwg D3640 Rev: _____ 2-Deburr and Blend rad intersection with deburring tool.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELIRINB0.750X1.250	Delrin Bar	4 ft (.4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELIRINB0.750X1.250	4	68	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Belt Guide	4.500Inches ± 0.030	4.530 4.470		
2	Belt Guide	0.800Inches ± 0.030	0.830 0.770		
3	Belt Guide	0.130Inches ± 0.030	0.160 0.100		
4	Belt Guide	0.310Inches ± 0.030	0.340 0.280		
5	Belt Guide	0.200Inches ± 0.010	0.210 0.190		
6	Belt Guide	0.400Inches ± 0.030	0.430 0.370		
7	Belt Guide	0.030Inches ± 0.030	0.060 0.000		

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Dev

DART Aerospace Ltd.
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 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S100524

Part: D3640 - 1

Job No: 180847

Serial No/Batch: S100524

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

Date: 06/09/16

Completed By _____

ad hand / Supervisor
approval Verification _____

QC / QA Coordinator
Approval _____

Root Cause							
Environment ☐	No Re-verification ☐	Pres ☐				Positioned Wrong ☐	
Design ☐	Operator ☐	Ben ☐				Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Cen ☐				Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Crai ☐				Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp ☐				Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐				Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐				Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐				Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐				Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐				Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐						
		OTHER : _____					

8	Belt Guide	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle
9	Belt Guide	0.230Inches $\pm$ 0.030	0.260 0.200	
10	Belt Guide	0.400Inches $\pm$ 0.030	0.430 0.370	
11	Belt Guide	0.625Inches $\pm$ 0.010	0.635 0.615	
12	Belt Guide	0.130Inches $\pm$ 0.030	0.160 0.100	Radius

Plex 7/17/18 12:46 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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